

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007143**Date Inspected:** 10-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR**CWI Name:** Steve Barnett**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge-K Components**Summary of Items Observed:**

Summary of Items Observed: On this date, Caltrans Quality Assurance Inspector (QA) Clete Henke was present at Oregon Iron Works, Inc. (OIW) in Clackamas, OR for observation of fabrication of the Hinge K Pipe Beams and related activities including in process welding and OIW Quality Control (QC) visual and nondestructive testing. The following observations were recorded:

OIW Fabrication Shop-Bay 3

Hinge-K Pipe Beam Fuse Sub-Assembly 120A-7:

a125 stiffener ring to a124-15 Fuse

The QA Inspector intermittently monitored OIW welder Mikhail Bannikov (WID B28) during in progress Submerged Arc Welding (SAW) at weld joint WM3-17 joining a125 stiffener ring to a124-15 Fuse Section. The QA Inspector observed as OIW QC Inspector Steve Barnett performed Magnetic particle Testing (MT) and Visual Inspection (VT) of completed root passes at weld WM3-17. Mr. Barnett stated that he had located no rejectable indications. The QA Inspector subsequently performed 100% VT & 10% MT verification at the location noted above finding the root pass to be in general compliance with contract documents. Please reference TL-6028 report for this date for details. The QA Inspector intermittently observed as welder B28 continued to deposit SAW fill and cover passes in the flat (1G) position in accordance with approved welding procedure 4020. The QA Inspector noted the OIW welder was maintaining continuous preheat utilizing two torches. An OIW helper was observed assisting welder B28 during SAW process. The QA Inspector observed OIW QC Inspector Steve Barnett regularly monitoring and recording the in process SAW parameters. The QA Inspector also intermittently observed in process welding parameters and determined that the SAW parameters and minimum preheat/interpass temperature appeared to be in general compliance with the contract requirements -- (35 volts, 585 amperes,

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457mm/min travel speed).

Hinge-K Pipe Beam Fuse Assembly 120A-2:

a124-3 to a124-11

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Assembly 120A-4:

a124-13 to a124-4

OIW QC Inspector Steve Barnett contacted the QA Inspector and stated that he intended to conclude Ultrasonic Testing on circumferential weld joint WM3-18 on assembly 120A-4 which had been initiated on the previous day. The QA Inspector subsequently randomly observed Mr. Barnett as he completed the testing referenced above. Mr. Barnett subsequently stated that he had located one indication which would require further evaluation.

Hinge-K Pipe Beam Fuse Assembly 120A-5:

a124-14 to a124-2

The assembly noted above was at A.G. Machine Works, Inc in Boring, OR for rough machining.

Hinge-K Pipe Beam Fuse Sub-Assembly 120A-6:

A124-9 to a124-1

The assembly noted above was complete and idle pending expiration of 72 hour cool down period prior to NDT per contract requirements.

Hinge-K Pipe Beam Base Assembly 102A-1:

a111-1 forging to a110-4 base plate

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Base Assembly 102A-4:

a111-4 forging to a110-4 base plate

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

OIW Fabrication Shop-Bay 6

Hinge-K Pipe Beam Fuse Assembly 120A-3:

The QA Inspector intermittently observed OIW qualified welder's Bounheune Savanh (WID S74) and Vincent Vu (WID V7) during in-process pick-up welding of Soudotape 316L stainless steel overlay to hinge k pipe beam fuse sub-assembly 120A-3. The weld joint is identified as 316L 3rd layer. Mr. Savanh and Mr. Vu were observed grinding low spots on completed 316L 3rd layer and subsequently welding the excavated low spots in the flat position utilizing automatic electro slag welding (ESW) overlay process with a .5mm x 60mm Soudotape 316L stainless electrode, filler metal brand Soudotape class EQ316L automatic. The QA Inspector observed OIW QC Inspector Steve Barnett regularly monitoring and recording the in process ESW parameters. The QA Inspector also intermittently observed in process welding parameters and determined that the ESW parameters (1175 amps, 26 volts, 254mm/min travel speed) and minimum preheat temperature of 70° F appeared to be in general compliance with the contract requirements and approved OIW Welding Procedure Specification (WPS) 7003.

Material, Equipment, and Labor Tracking:

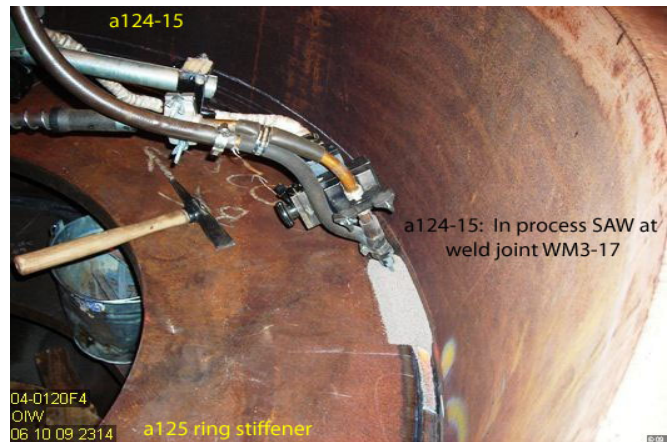
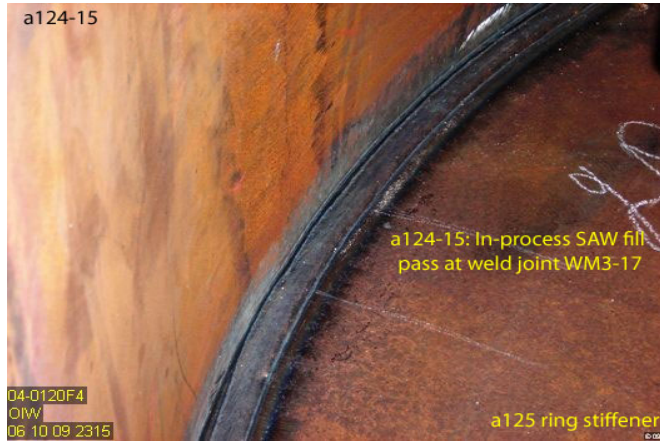
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The QA Inspector performed verification of personnel involved with this project and equipment in use. The QA Inspector accounted for 4 OIW production personnel and 1 Quality Control Inspector present on this date.



### Summary of Conversations:

As noted in the body of the report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Henke,Clete

Quality Assurance Inspector

**Reviewed By:** Adame,Joe

QA Reviewer

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